

# Work Order ID 72601

Wednesday, August 03, 2011 1:03:45 PM



Page 1

Item ID:	D4003-049	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tank Vent Line Assembly					
Start Date:	8/3/2011	Start Qty:	6.00	Cust Item ID:		
Required Date:	8/8/2011	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	11-08-3	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4003	A								

100		0.00							
Purchasing		0.00							
Purchasing	<b>Memo</b> Issue P/O: 11/19 Manufacture as per Dwg D4003 Ship mat'l to vendor Possible Supplier: Cintube Material release note required								

11-08-3

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging		0.00							
Packaging	<b>Memo</b>								

CY 11/08/26 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72601

Wednesday, August 03, 2011 1:03:45 PM



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Item ID: D4003-049

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Vent Line Assembly

Start Date: 8/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									
124	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
127	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

8 u/08/76

(4)

4X Ø M-11/08/2011

u/8/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72601**

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Wednesday, August 03, 2011 1:03:45 PM

Item ID: D4003-049

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Vent Line Assembly

Start Date: 8/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 193

0.00



Packaging

Memo

0.00

Packaging

11/8/29 df

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/29 dfMF  
11-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 03, 2011 1:03:50 PM

Page 1

Work Order ID: 72601

Parent Item: D4003-049

Parent Item Name: Tank Vent Line Assembly

Start Date: 8/3/2011


Required Date: 8/8/2011

Start Qty: 6.00


Required Qty: 6.00

Comments: IPP rev A 10.01.05 new Issue Prelim EC verified by: DD IPP Rev B  
10.05.13 ecn 10-562 EC verified by:DD


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN818-8D  Nut		Purchased	No			100	Each	18.0000	1	6			
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Location	Loc Qty	Loc Code
ST321	10	
118112	10	
ST331	8	
115594 ✓	3	
117514	5	

M6061T6T0.500W.035  6061-T6 RD Tube .500 x.035W		Purchased	No			100	f	140.0000	1	6			
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Location	Loc Qty	Loc Code
MAT014	140	
4692	140	

MS20819-8D  Sleeve		Purchased	No			100	Each	30.0000	1	6			
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Location	Loc Qty	Loc Code
ST323	30	
114544	30	

D4003-049P  TANK VENT LINE ASSEMBLY		Purchased	No			110	Each	0.0000	1	6			
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CL11/08/10

3  
3

CL11/08/10

12

CL11/08/10

6

MF 11-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

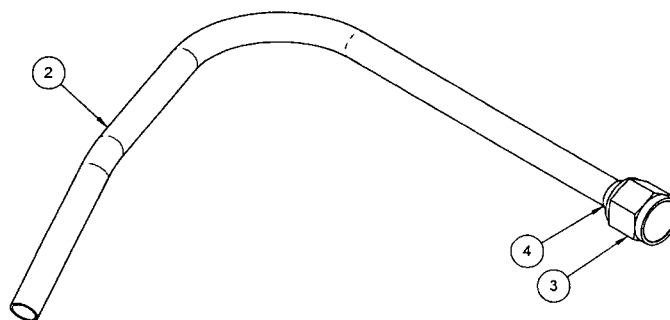
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	QTY. -049	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4003-049	TANK VENT LINE ASSEMBLY	JCA-M47-2-17
2	1	D4003-9	VENT LINE	
3	1	AN818-8D	NUT	
4	1	MS20819-8D	SLEEVE	



D4003-049 TANK VENT LINE ASSEMBLY

W10' 72601  
C/L1108110

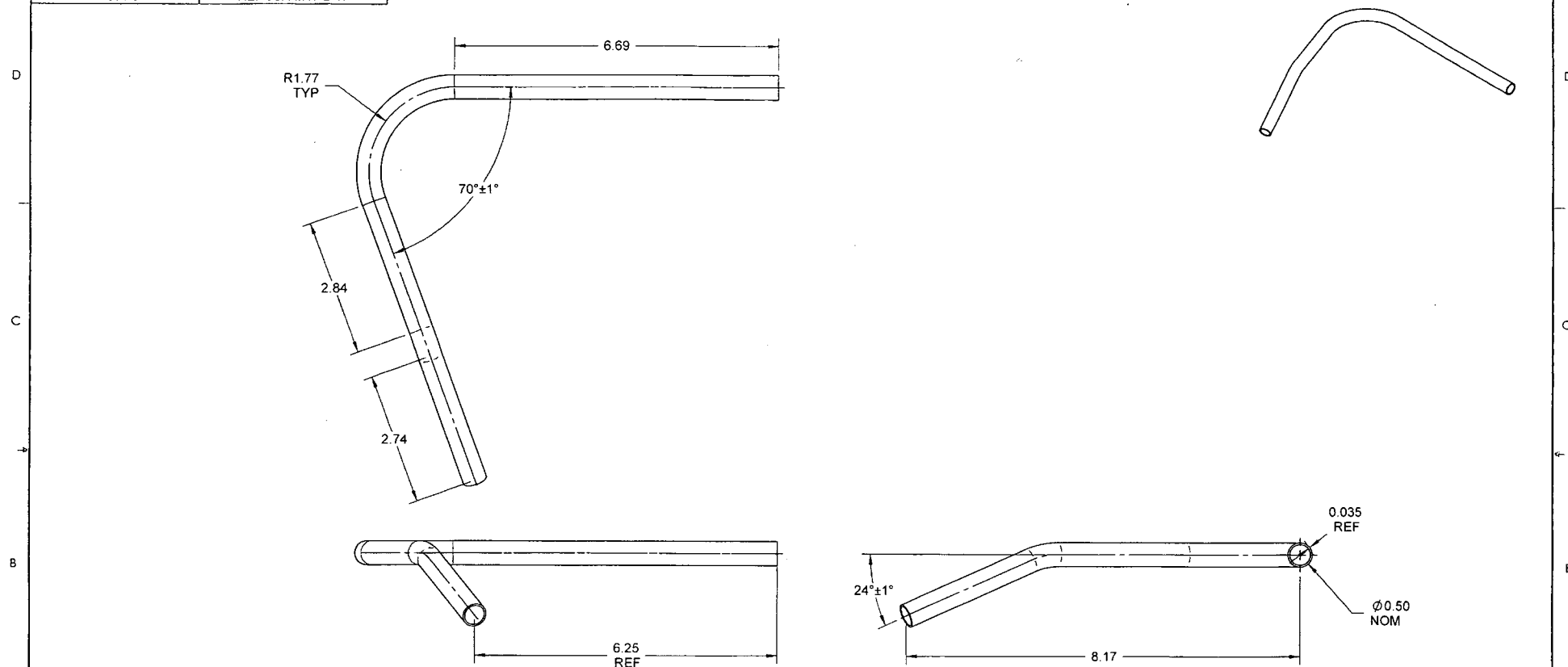
**RELEASED**  
2010-05-05  
NMP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-049" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4003	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		LINE	NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-9	REF JCA-M47-2-17



# **D4003-9 VENT LINE**

**RELEASED**  
2010-05-05  
ANN

## **NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.500 X 0.035 WALL THICKNESS  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
REF DART SPEC M8061T60.500W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4003</b>	REV. A
MFG. APPR.		TITLE <b>LINE</b>	SHEET 7 OF 9
APPROVED			SCALE
DE APPR.			NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

CINTRAGE DE PRÉCISION, DE TUBES, TUYAUX, CORNIÈRES, POUTRES,  
 PROFILÉS EN "U", ET SERPENTINS.  
 MANUFACTURIER DE GÉNÉRATRICE À VAPEUR, ÉLÉMENT CHAUFFANT,  
 RÉCUPÉRATEUR DE CHALEUR, ÉCONOMISEUR ETC.  
 PRECISION BENDING OF TUBES, PIPES, ANGLES, BEAMS, CHANNELS, COILS.  
 MANUFACTURERS OF STEAM GENERATORS, THERMAL FLUID HEATERS,  
 WASTE HEAT RECOVERY UNITS, ECONOMIZERS.

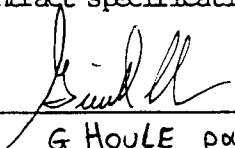
333 BOUL. ST-JOSEPH, LACHINE, QUÉBEC H8S 2K9  
 TÉLÉPHONE: (514) 364-6426 FAX NO: (514) 636-3336

## LETRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Client/Customer DART AEROSPACE LTD Date: AUG. 25/  
 N° de commande du client/Customer order No: PO14619  
 Notre n° de feuille de route/Our order No: 115539  
 Notre n° de dessin/Our drawing No: —  
 Description/Customer drawing No: D-4003-9 rev. A  
 Nom de la piece/Part Name: VENT LINE  
4 pieces

La présente est pour certifier que le matériel ci-haut mentionné se conforme aux exigences contractuelles de qualité et/ou de la confirmation de la commande, qu'il a été produit, inspecté et testé selon les spécifications standards applicables de notre programme de contrôle de la qualité, du contrat et du(des) dessin(s).

This is to certify that the material covered by this document conforms to the quality requirements of the purchase order or contract, that the material has been produced, verified and tested according to applicable standard specifications listed in our quality control procedures, contract specifications and/or drawing(s).

Signé par/Signed by: 

G. HOULE pour B. OVERBURY

Directeur des services techniques/Technical Services Director

Pour la Compagnie Cintube Ltée/On behalf of Cintube Ltd.

CLIENT:  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.

HAWKSBURY  
ON K6A 1K7

EXPED. ATO :  
SAME

Page 1 of 1

**CINTUBE** LTEE/LTD

☒ 333 BOUL. ST-JOSEPH, BUILDING # 105 ☐ 1250 MATHESON BLVD. EAST  
LACHINE, QUEBEC MISSISSAUGA, ONTARIO  
H3S 2K9 L4W 1R2  
TEL: (514) 634-3592 TEL: (905) 625-1900  
FAX: (514) 636-3336 / 8625 FAX: (905) 625-1500

BON TRAVAIL:  
WORK ORDER M - 115539

REP. PATRICK ZALATAN

DATE: 04-Aug-11  
COMMANDE #: PO14619  
ORDER #:

CONTACT PHONE #: (613) 632-9577 EXT. #:  
FAX #: (613) 632-1053

CONTACT PHONE #:

(613) 632-9577

EXT.#:

FAX #:

(613) 632-1053

CLIENT NO.	MAT'L PAR / MAT'L BY	REFERENCE	MODE DE PAIEMENT / TERMS OF PAYMENT					
MDAR72	CLIENT		1.5 % - 10 DAYS / NET 30					
TRANSPORT		DATE LIV. / DELIV. DATE		CONTACT				
PUROLATOR COLLECT #7684382		10 A/TO 15 JOURS/DAYS		LINDA LACELLE				
QUANT	EXP.	DIMENSION / SIZE	EP / WALL	DESCRIP. MAT'L. / MAT'L DESCRIP.	DEG.	RAY. / RAD.	TANGENTE / TANGENT	INSTRUCTIONS
6	4	0.5 OD	0.035	PART NO. DART D4003-9 TUBE ALUMINIUM	MULTIPLE BENDS	1.77 CLR	SEE DRWG: D4003-9	FINAL CUT & FLARE
1	1			NUTS & SLEEVES BY DART LETTRE DE CONFORMITE				

CL11108124

Sulco/26

QIC

Notes

\*\*\* LETTER OF COMPLIANCE AND MILL TEST REPORT MUST BE SENT IN DOUBLE COPIES -- ONE ATTACHED TO PACKAGE/IN BOX AND ONE ATTACHED TO PAPERWORK/PACKING SLIP. \*\*\*

CATEGORIE ISO  
ISO CATEGORY  
ASME

1	2	3
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/>		

CERTIFICAT D'ANALYSE  
MILL TEST CERTIFICATE

OUI  
YES ☒

LETTRE DE CONFORMITE  
LETTER OF COMPLIANCE

OUI  
YES ☒

M - 115539

mta 1-25-2011